Each

40 Um:

Tuesday, 15/08/2006 7:48:59 AM Date: Linda Lacelle User: **Process Sheet Drawing Name** : DOUBLER : CU-DAR001 Dart Helicopters Services . Customer Job Number : 28108 : 12105 **Estimate Number** : NIA : D32011 **Part Number** P.O. Number S.O. No. : NIA - D3201 REV B **Drawing Number** This Issue : 15/08/2006 : N/A : NC **Project Number** Prsht Rev. : 10/08/2006 : MACHINED PARTS **Drawing Revision** Type First Issue :NIA : 25635 Material **Previous Run** : 30/08/2006 **Due Date** Written By Checked & Approved By Removed from 9 Digit 06-01-25 JLM : Est Rev:A Comment **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: M2024T3S040 2024-T3 .040 sheet 1.0 0.2898 sf(s)/Unit Total: 11.5920 sf(s) Comment: Qty.: Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Identify for D3201-1 Batch: M /0 / 4/1 2.0 WATER JET **Comment: FLOW WATER JET** INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



Comment: SECOND CHECK

SMALL FAB 5.0

QC8

4.0

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

**Deburr Stack** 

06.08.21.

(VO)

Date: User:

Tuesday, 15/08/2006 7:49:00 AM

Linda Lacelle

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: DOUBLER** 

Job Number: 28108

Part Number: D32011

Job Number:



Seq. #:

**Machine Or Operation:** 

**Description:** 

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1



7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PACKAGING RESOURCE #1



8.0

PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST



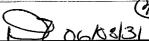
9.0

DC



Comment: DOCUMENT CONTROL

Inspection Level 21



Job Completion



C Lolelo 2/30

DOCUMENT CONTROL

Thursday, 10/08/2006 9:56:10 AM

User:

Linda Lacelle

### **Process Sheet**

Customer Job Number : CU-DAR001 Dart Helicopters Services

**Drawing Name** 

: DOUBLER

: 28108

Type

**Estimate Number** P.O. Number

: 12105

: 10/08/2006

**Part Number** 

: D32011

: D3201 REV B

: 30/08/2006

Prsht Rev.

: NC : // S.O. No. : **Drawing Number** Project Number

N/A ' : B **Drawing Revision** 

First Issue **Previous Run** 

Checked & Approved By

: 25635

Material **Due Date** 

40 Um:

Comment

This Issue

Written By

: Est Rev:A

Removed from 9 Digit 06-01-25 JLM

: MACHINED PARTS

Qty:

Each

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

1.0

M2024T3S040

2024-T3 .040 sheet





Comment: Qty.:

0.2898 sf(s)/Unit Total: 11.5920 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040) Identify for D3201-1

Batch:

SHEAF



2.0

SHEAR

Comment: SHEAR

Cut blank: 8.030" x 4.950"

3.0 HAAS1 HAAS CNO VERTICAL MACHINING #1



**Comment: HAAS CNC VERTICAL MACHINING #1** 

1-Machine D3201-1 as per Folio FA337 and Dwg D3201Stack of 10Identify as D3201-1 QC2

4.0

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



5.0

QC8

Comment: SECOND CHECK



# **Dart Aerospace Ltd**

	WORK ORDER C	HANGES				
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
_	STEP		STEP PROCEDURE CHANGE By			

Part No:	PAR #:	Fault Category:	NCR: Yes	No	DQA:	Date:	
			QA: N	/C C	losed:	Date:	

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
						,	i	
						-		
·								

NOTE: Date & initial all entries

Date:

Thursday, 10/08/2006 9:56:10 AM

User:

Linda Lacelle

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: DOUBLER** 

Job Number: 28108

Part Number: D32011

Job Number:



Seq. #:

**Machine Or Operation:** 

**Description:** 

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE'1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PACKAGING RESOURCE #1



**Comment: PACKAGING RESOURCE #1** 

Identify and Stock

Location:\_

10.0

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



#### **Dart Aerospace Ltd**

Dail Ae	rospace	ELU		·							
W/O:			W	ORK ORDER CHANGES			·	****			
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	y Date (		Date 0		Approval Chief Eng / Prod Mgr	Approva QC Inspector
<u> </u>						·					
Part No	:	PAR #:	Fault Cat	egory: N	ICR: Yes	No DQ	A:	_ Date: _			
					QA: N	C Close	d:	_ Date: _			
NCR:			WORK ORE	DER NON-CONFORMANO	CE (NCR	)			,		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description Chief Eng	Sign & Date		<b>cation</b> ion C	Approval Chief Eng	Approval QC Inspector		
									74		
						1					

£.

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	80186
Description: Doubler	Part Number:	D3201-1
Inspection Dwg: D3201 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.50	+/-0.030	RO.50	<b>V</b>		RADIUS GU	498
3.57	+/-0.030	3.56	<b>√</b>		Hight Gong	₹
R0.12	+/-0.030	RO.12	$\sqrt{}$		RADIUS GUR	
8.00	+/-0.030	8.00	1		Vern	)
0.58	+/-0.030	0.59	$\checkmark$		Hight GUA	je
4.89	+/-0.030	4.889	$\checkmark$		verN	<u>U</u>
R0.25	+/-0.030	RO.25	$\sqrt{}$		RAdius Gu	nosl
0.040	+/-0.010	0.041	V		VerN	0
		-				

,			
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 05 08 17	Date: 06.06.20	Date:	N/A

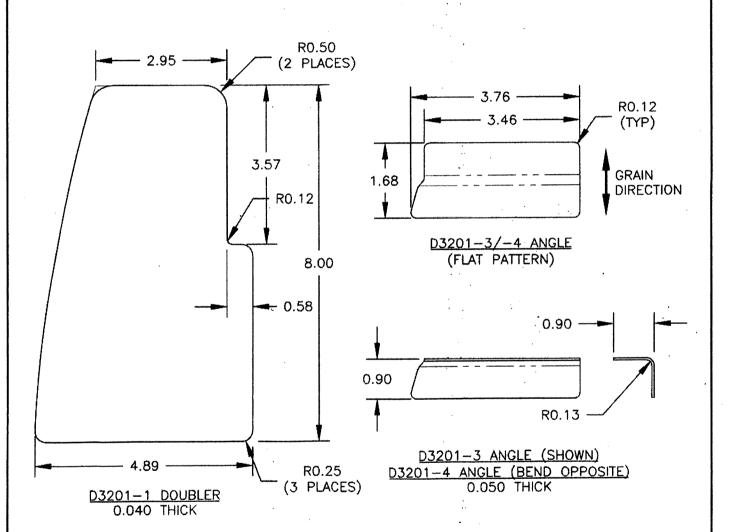
Γ	Rev	Date	Change		Revised by	Approved
Ī	Α	03.11.28	New Issue	P/O D412-698-015	KJ/RF	





DESIG	4	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	(ED <sub>21</sub>	APPROVED /	DRAWING NO. REV. B
	-11-	1	D3201 SHEET 1 OF 1
DATE			TITLE SCALE
03.1	1.03		DOUBLER 1:2
Α		03.08.07	NEW ISSUE
В		03.11.03	MODIFY D3201-1, ADD D3201-3/-4

RELEASED 03.1114



#### D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)
  - (REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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